Work Order ID 62825	Work	Orde	r ID	62825
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Friday, October 08, 2010 12:47:54 PM

Strut

Required Date: 10/15/2010



Page 1

Item ID:

D3518-1

Accept



Setup Start



Revision ID:

Item Name:

10/8/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Date: 1010

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours** **Tool ID**

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Draw Nbr

Revision Nbr

D3518 Rev B

Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

0.00

0.00

Turn as per Dwg D3518, □1-Face to Lengh and Drill & Tap.

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120

Mill Conv

Conventional Milling Machine

Memo

CONVENTIONAL MILLING MACHINE

0.00

0.00

Drill as per Dwg D3518. □1-Drill 2x .191" holes & 1x .0625" hole

Dart	Aer	osp	oace	Ltd
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W/O:			V	VORK ORDER CH	ANGES					· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			7.00							
									•	
Part No		PAR #:	Fault Ca	tegory:	NCF	R: Yes N	lo DQA:		Date:	
	R	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date:	
NCR:		V	VORK OR	DER NON-CONFO	RMANCE	(NCR)	1			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip Chief Eng	Section B	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
al administration										
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Work Order ID 62825

Friday, October 08, 2010 12:47:54 PM



Page 2

Item ID:

D3518-1

Accept

Setup Start

Revision ID:

Start Date:

Item Name:

Strut

Required Date: 10/15/2010

10/8/2010

Start Qty: 4.00

Req'd Qty: 4.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ **Work Center ID**

130

QC Quality Control **Operation** Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Insp. Number Stamp

140

Quality Control

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

SL 10/11/15

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

4 BR 10-11-15.

									ı
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
					·				
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA:	Date:	
	Re	esolution:	Disposition	n:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description			erification Section C	Approval Chief Eng	Approval QC Inspector
		Geomotiva	Chief Eng	Chief Eng	Da	ite		Office Ling	QO mispector
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Work Order ID 62825

Friday, October 08, 2010 12:47:54 PM



Page 3

Item ID:

D3518-1

Accept

Setup Start

Stop

Start



Revision ID:

Item Name:

Required Date: 10/15/2010

Strut

10/8/2010

Start Qty: 4.00

Req'd Qty: 4.00



Date: _____

Cust Item ID: Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Date:

Stop

Reject

Qty

Run

Accept

Qty

Insp.

Stamp

Reject

Number

Sequence ID/

Work Center ID

160

Powdercoat

Powder Coating

Operation **Description**

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

m115291

Memo

0.00

0.00

******Mask threads with AN6 bolt******** START TIME:

170

QC3- Inspect Part Finish

0.00 => JU 10/11/16

Memo

0.00

Quality Control

180

Packaging Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00

W/O:		7	W	ORK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				77-7-7-7-7-7-7-7-7-7-7-7-7-7-7-7-7-7-7-7					
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DO	QA:	_ Date: _	
	Res	solution:	Dispositio	n:	_ QA: N/C	Closed:	•	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B	Verif	ication	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector
	1								
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						1			

Work Order ID 628	82:	5
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Friday, October 08, 2010 12:47:54 PM



Page 4

Item ID:

D3518-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Strut

Required Date: 10/15/2010

Start Qty: 4.00 10/8/2010

Req'd Qty: 4.00

Operation

Description



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

QC21- Final Inspection - Work Order Release

Tooling:

Date:

Start Run

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/

Work Center ID

190

QC

Memo

0.00

0.00

Tool # Plan

Accept Qty Code

Reject Qty

Reject Insp. Number Stamp

Quality Control

W/O:			WO	RK ORDER CHANG	SES				
DATE	STEP	PR	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Floa Wgr	
·		74.4.4.4							
,				·					
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes I	No DQ	A :	Date:	
		solution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC		444	tion B	Verific	ation	Approval	Approval
	JOIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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				46 V.					

Picklist Print

Friday, October 08, 2010 12:48:02 PM

Work Order ID: 62825

Parent Item: D3518-1

Parent Item Name: Strut

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A

New Issue 06-11-20 JLM

IPP rev B

rev B dwg 07.04.09 EC

Component	Item	ID
Item Name		

Replacement Mfg/ Item ID

Purch

Bin **Primary** Item Location

Last Location

Route Seq ID Unit of Measure Hand

Qty on

Qty per Kit

Total Qty

Date Issued Issued

Status

Page 1

M6061T6H0.875

Purchased

No

100

f

24.0000

Loc Code

1.1

4.631579

6061-T6 HexBar .875

Location MAT012

110980

Loc Qty 24

24

Qty

4.75 A 10/11/10

Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: NCR: Disposition: QA: N/C Closed: Date: NCR: NOR: NOR: NOR: Date: NCR: NOR:	
Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)	
Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)	
Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)	
Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)	
Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)	
Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STEP Description of NC Corrective Action Section B Verification Approval Approval Approval Approval	oval
Section A Section A Section A Section A Section Chief Eng Chief En	

DART AEROSPACE LTD	Work Order:	42825
Description: Strut	Part Number:	D3518-1
Inspection Dwg: D3518 Rev: B		Page 1 of 1

	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	X	First Artic	:le	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
13.225	+/-0.010	13.223					
1.000	+/-0.010	1.002					
0.375	+/-0.010	.379	~				
1.500	+/-0.010	1-498					
Ø0.191	+0.005/-0.001	.193	-				
Ø0.191	+0.005/-0.001	.194					
Ø0.062	+0.004/-0.001	, 062					

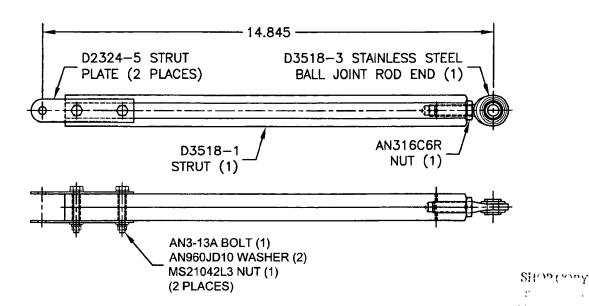
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Measured by:	A)	Audited by:			Prototype App	proval:	N/A
Date: /t	/11/15	Date:	10/11/15			Date:	N/A
	/ /						

Rev	Date	Change	Revised by	Approved
Α	08.05.06	New Issue	KJ/DD ♂	<i>M</i>

Dart Ae	rospace	Ltd						
W/O:		****	WO	RK ORDER CHANC	GES			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA: _	Date: _	
	Re	solution:	Disposition	QA: N/C CI	osed:	Date: _	······································	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)		
DATE	OTED	Description of NC		Corrective Action Sec	tion B	Verificatio	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	1	***				+	 	



		1	1		
	DESIG	B	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
į	CHEC		APPROVE	DRAWING NO.	REV. B
	1	H	-	D3518	SHEET 1 OF 3
	DATE			TITLE	SCALE
	06.1	0.23		BASKET (A119) STRUT	1:3
	Α		06.06.21	NEW ISSUE	
	В		06.10.23	RE-DESIGN	

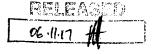


D3518-041 STRUT ASSEMBLY

QTY -041	Part Number	Description
Х	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

NOTES:

1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER



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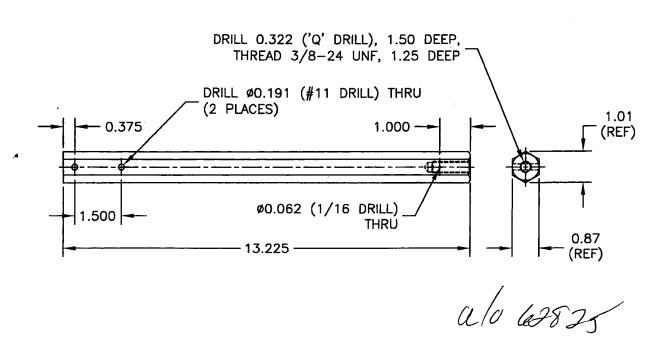
W/O:		WORK ORDER CHANGES								
DATE	STEP			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	2									
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Part No: _		PAR #:	Fault Category	y:	NCR: Yes	No DQA:	Date: _	
	Resolution:		Disposition: _		QA: N/C Clo	sed:	Date:	

NCR:		'	WORK ORD	ER NON-CONFORMANCE	E (NCR)		•	
		Description of NC		Corrective Action Section B	Verification Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
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1	1.		4 -
DESIGN 3	DRAWN BY	DART AEROSPA HAWKESBÜRY, ONTARIO,	
CHECKED	APPROVED/	DRAWING NO.	REV. B
PH	1	D3518	SHEET 2 OF 3
DATE		TITLE	SCALE
06.10.23		BASKET (A119) STRUT	1:3



D3518-1 STRUT

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER
 - AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER
 - AMS-QQ-A-200/8 (OR AMS 4160)
 - (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

ESLEASED

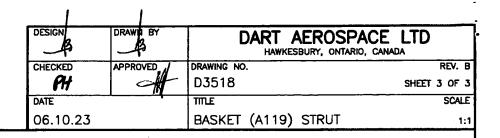
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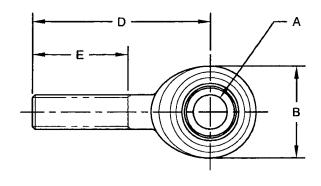
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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	_ Date:		
Resolution: Disposition: QA: N/C Clos					losed:		Date: _		
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCI	₹)	* '		
DATE	STEP	Description of NC	Corrective Action Section B				cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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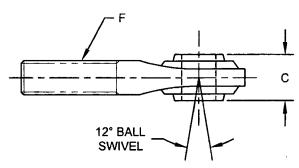




SPECIFICATION CONTROL DRAWING







DART P/N	Α	В	С	D	Е	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF. RH	4012	McMASTER-CARR, P/N 2458K14
				,		0111,1111		17172-1001(1-1

^{*} Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:	1	PAR #: Fault Category: NCR: Yes No DQA: Date: Olution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) Description of NC Corrective Action Section B Verification Approval App									
DATE	STEP	PRO		· · · · · · · · · · · · · · · · · · ·	•	Ву	Date	Qty	Chief Eng /	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	Fault Category: NO				A :	Date:		
	R	esolution:	Dispositio	n:							
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE	E (NCF	7)	<u>.</u> .			
DATE	STEP	Description of NC			tion B	•	Verific	ation	Approval	Approval	
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